

Date: Monday, 2/19/2007 8:07:53 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	GASKET
Job Number	30754		
Estimate Number	12720		
P.O. Number	N/A	Part Number	D353623 Rev A
This Issue	2/19/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D3536 UNDER REVIEW PTH 07-02-19
First Issue	N/A	Project Number	N/A
Previous Run	N/A	Drawing Revision	U/R
Written By		Material	N/A
Checked & Approved By	<u>JLM</u> 07.02.19	Due Date	2/26/2007
Comment	Est Rev:A New Issue 07-02-14 JLM		

Additional Product

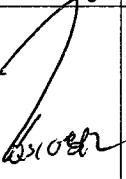
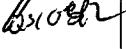
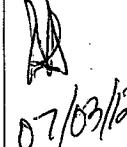
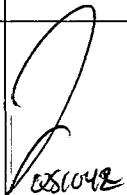
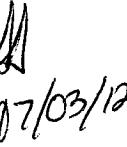
Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MNEO60S063	NEOPRENE SHEET 0.063 Comment: Qty.: 1.4033 sf(s)/Unit Total : 16.8399 sf(s) NEOPRENE SHEET 0.063 Batch: <u>M103104</u> SAD 07/03/10
2.0	WATER JET	FLOW WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D3536 Dwg Rev: <u>A</u> Prog Rev: <u>A</u> <u>WATER JET</u> SAD 07/03/10 2-Deburr if necessary
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE Comment: INSPECT PARTS AS THEY COME OFF MACHINE SAD 07/03/10 (12) DTD
4.0	QC8	SECOND CHECK Comment: SECOND CHECK Mo7/03/12 (12)
5.0	PACKAGING 1	PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____ <u>JB07/03/13 (12) CW</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/03/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/03/14 	2.0	water jet didn't cut one correctly "Scrap one piece"	 	Scrap and destroy replace	07/02/14 SNV	 07/03/12	 	 07/03/12

NOTE: Date & initial all entries

Date: Monday, 2/19/2007 8:07:53 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 30754

Part Number: D353623

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



(12)

Comment: FINAL INSPECTION/W/O RELEASE

2007/03/14

Job Completion



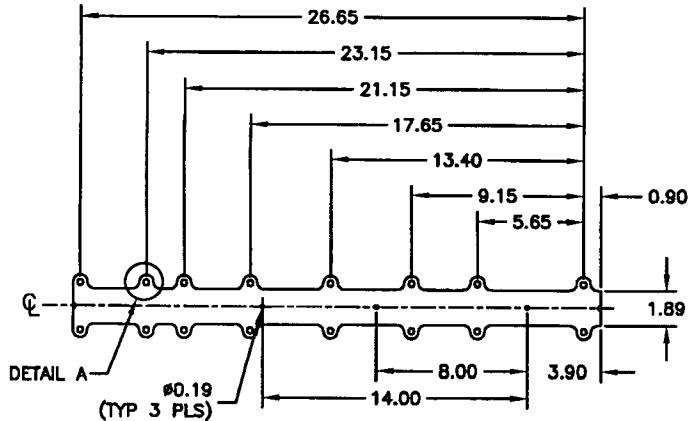
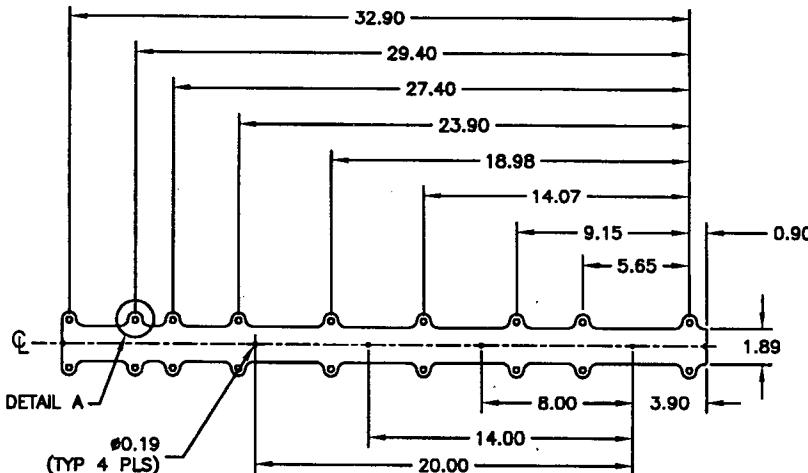
U 07/03/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

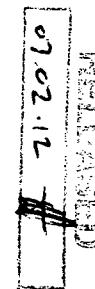
NOTE: Date & initial all entries

DARTRELEASED
09.02.12**D3536-11 GASKET****D3536-13 GASKET****NOTES**

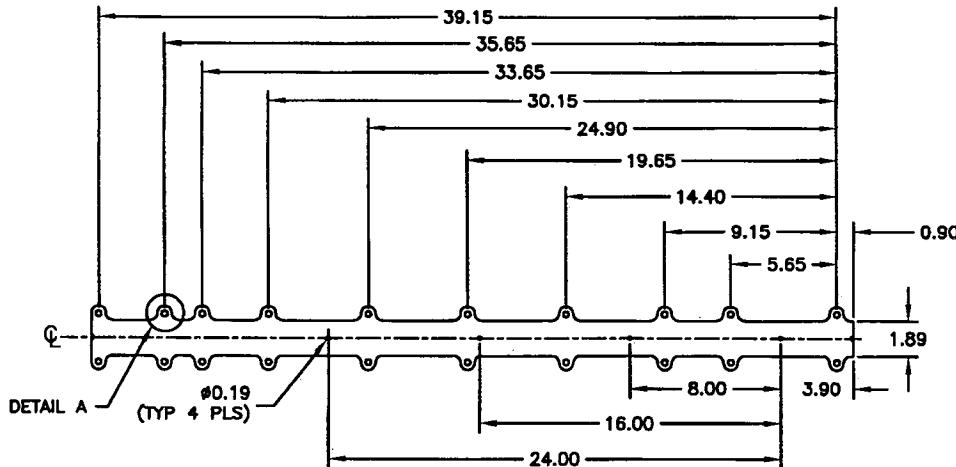
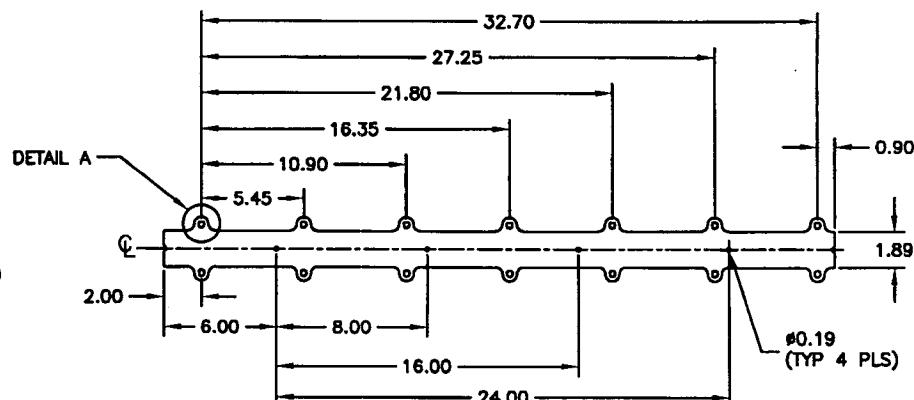
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT $\frac{Q}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30754

DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED MH	APPROVED MH	DRAWING NO. D3536
DATE 06.10.25	TITLE GASKET	REV. A SHEET 1 OF 6 SCALE 1:10

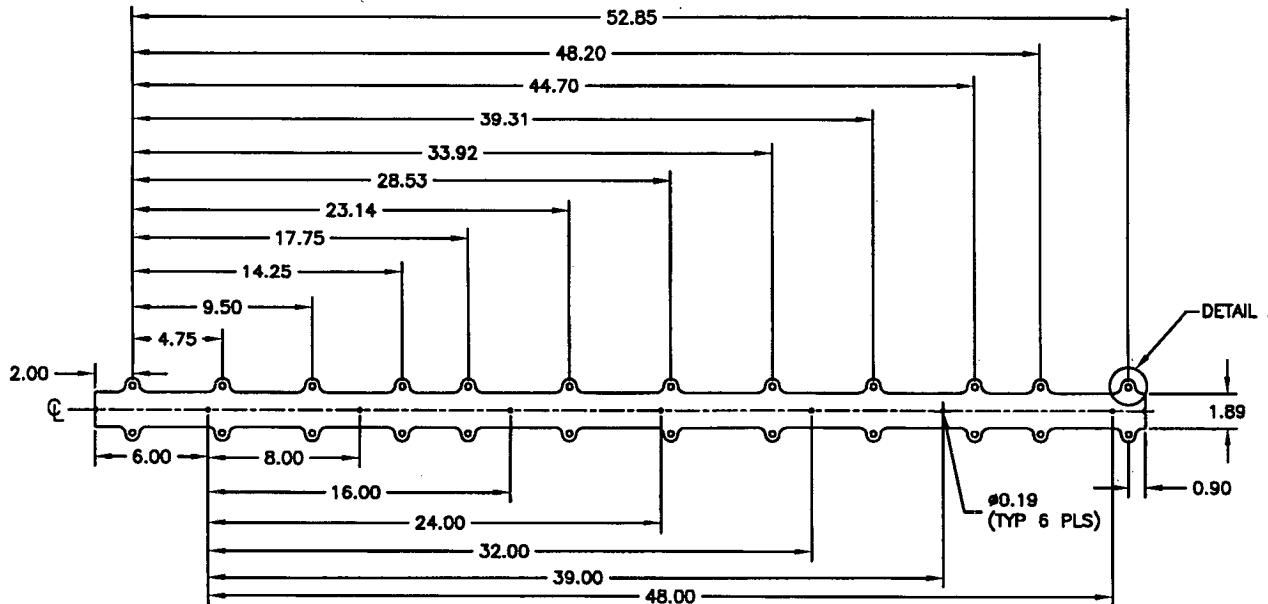
DART

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CHECKED MH	APPROVED MH	DRAWING NO. D3536
DATE 06.10.25	TITLE GASKET	REV. A SHEET 2 OF 6 SCALE 1:10

**D3536-15 GASKET****D3536-21 GASKET**

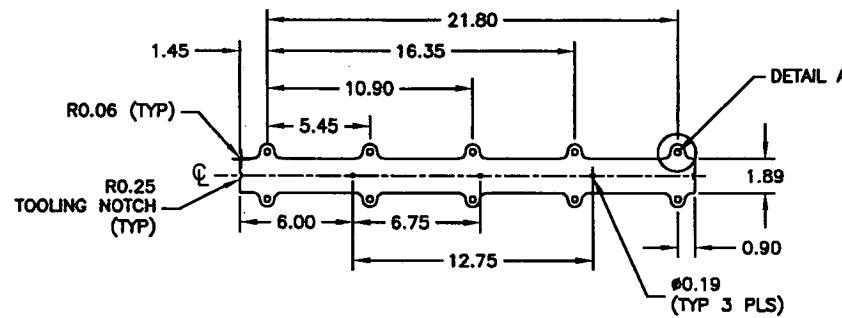
- NOTES**
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 - 2) FINISH: NONE
 - 3) PART IS SYMMETRICAL ABOUT $\frac{1}{2}$
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
 - 7) SEE PAGE 6 FOR DETAILS AND SECTION

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DART07-02-12
D3536-23 GASKET**D3536-23 GASKET**

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WORK ORDER
NO. 30754

- NOTES**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
 - 2) FINISH: NONE
 - 3) PART IS SYMMETRICAL ABOUT $\frac{1}{4}$
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
 - 7) SEE PAGE 6 FOR DETAILS AND SECTION

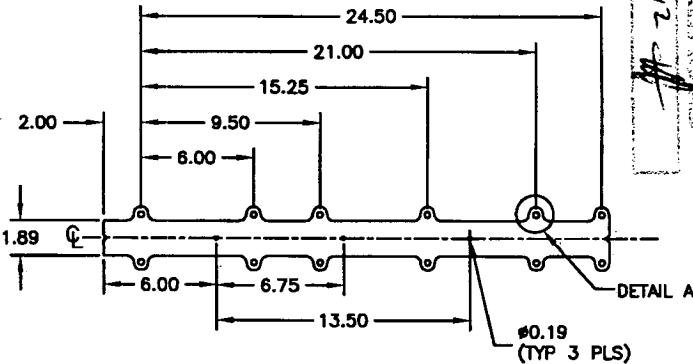
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CB	CB	PRT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
PH	MA	D3536
DATE		TITLE
06.10.25		GASKET
SCALE		SHEET 3 OF 6
		REV. A
		1:10

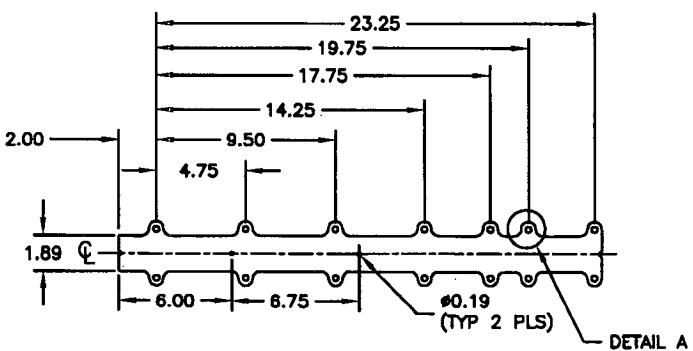
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DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED PH	APPROVED PH	DRAWING NO. D3536
DATE 06.10.25		SCALE 1:10

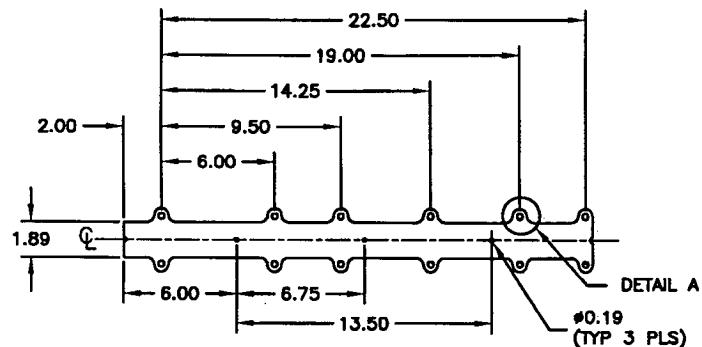
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D3536-33 GASKET



D3536-35 GASKET



D3536-31 GASKET

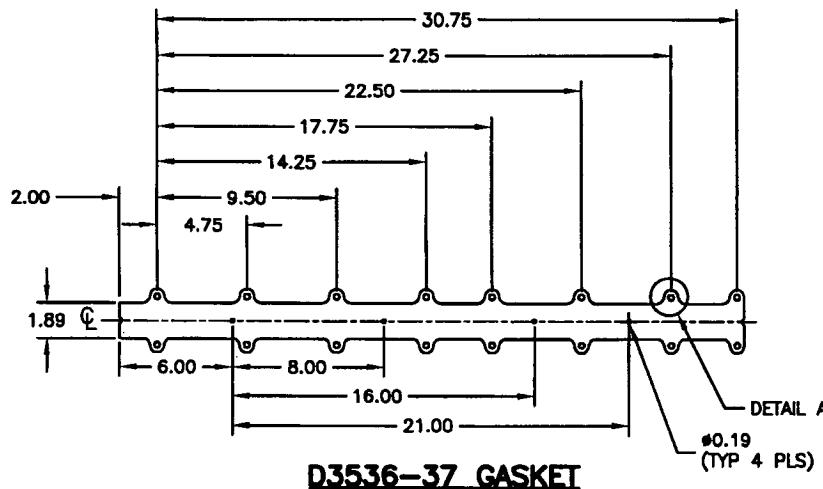
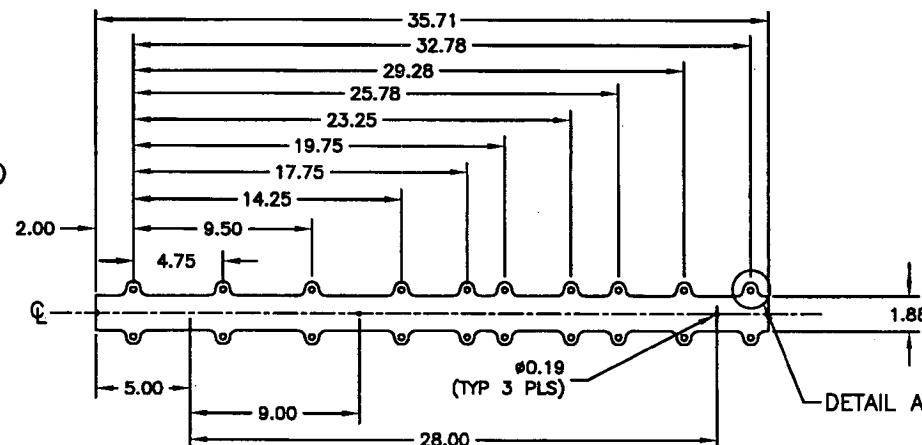
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WORK ORDER
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- NOTES**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
 - 2) FINISH: NONE
 - 3) PART IS SYMMETRICAL ABOUT $\frac{1}{4}$
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
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DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED PH	APPROVED PH	DRAWING NO. D3536
DATE 06.10.25	TITLE GASKET	SHEET 5 OF 6 SCALE 1:10

07.02.12

**D3536-37 GASKET****D3536-39 GASKET****Copyright © 2006 by DART AEROSPACE USA, INC.**

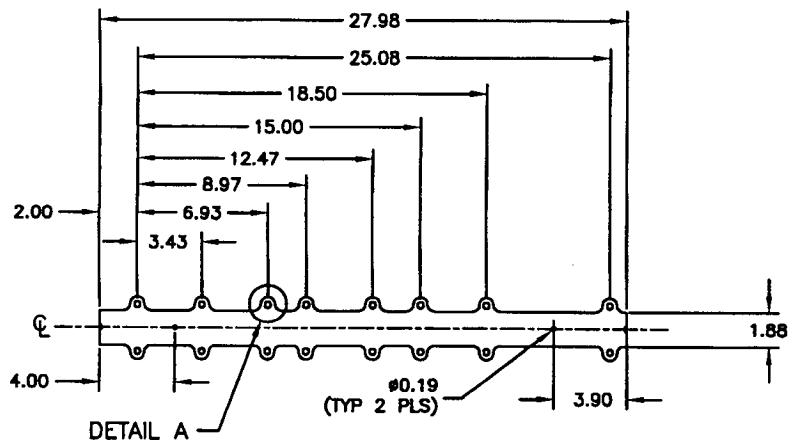
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WORK ORDER

NOTE:

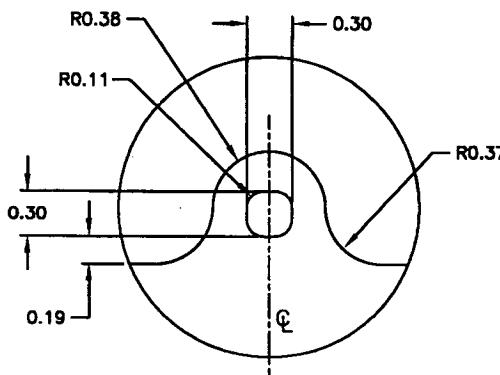
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

DART**D3536-41 GASKET**

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WITHOUT NOTICE
WORK ORDER
NO. 30154

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT $\frac{C}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

DETAIL A

DESIGN C.B	DRAWN BY C.B	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED M	APPROVED M	DRAWING NO. D3536	REV. A SHEET 6 OF 6
DATE 06.10.25		TITLE GASKET	SCALE 1:10

DART AEROSPACE LTD

Work Order: 30754

Description: basket

Part Number: D3536-23

Inspection Dwg: A Rev: A

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

<input checked="" type="checkbox"/>	First Article	<input checked="" type="checkbox"/>	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Eject	Method of Inspection	Comments
52.85	+/- 0.030	52.875	/		M-T / vern	
48.20	+/- 0.030	47.220	/		M-T	
49.70	+/- 0.030	49.68	/		M-T / vern	
39.31	+/- 0.030	39.50	/		M-T / vern	
33.92	+/- 0.030	33.95	/		M-T / vern	
28.53	+/- 0.030	28.56	/		M-T / vern	
23.14	+/- 0.030	23.170	/		M-T / vern	
17.75	+/- 0.030	17.75	/		M-T	
14.25	+/- 0.030	14.25	/		M-T	
9.50	+/- 0.030	9.50	/		M-T	
4.75	+/- 0.030	4.75	/		M-T	
8.00	+/- 0.030	8.02	/		Vern	
16.00	+/- 0.030	16.02	/		Vern	
24.00	+/- 0.030	24.02	/		Vern	
32.00	+/- 0.030	32.01	/		Vern	
39.00	+/- 0.030	39.01	/		Vern	
48.00	+/- 0.030	48.00	/		Vern	
Ø0.19	+/- 0.030	Ø0.193	/		Vern	
Ø0.30	+/- 0.030	0.317	/		Vern	
0.30	+/- 0.030	0.317	/		Vern	
1.89	+/- 0.030	1.91	/	at	Vern	

Measured by:	SAD
Date:	07/03/10

Audited by:	
Date:	

Prototype Approval:	
Date:	

Rev	Date	Change
A		New Issue

Revised by	KJ/JLM	Approved
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